Work Order ID 100746

Quality Control

100746

Page 1

Setup Start

May 1, 2013 7:07:53 AM D3238-15 Item ID: D3238-15 Accept B100746 Revision ID: Plate Item Name: 4/30/13 **Start Date:** Start Oty: \5.00 Required Date: 4/30/13 Req'd Qty: 5.00 Reference: Process Plan: Approvals: 0C: Date: SPC (Y/N): : DOC: • Work center is - worthpittin Draw Nbr Revision Nbr D3238 Rev C 100 0.00FLOW WATER JET *100* Waterjet 0.00 Memo FLOW CNC Waterjet T-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-Deburr if necessary -5050 ·070 6061.020 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* OC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 *120* QC Memo

N900040100 Cust Item ID: Customer: Run Start Date: Date: Rome Namber Schaff 12 12

												DQA:	Date	e:
NCR:	Yes	/ No					WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE	·		
												QA Closed:	Date	<u> </u>
Nork Orr	ler:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fa			Crosstube Small Fab Finishing Composite	ab Prod. Eng. Coor. Quality ng Rec/Store/Packaging Other			
Root					Des	cri	otion of work order update	Ti	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		c	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator faterial etup other rocess upplier raining														
				<u>:</u>				AUL	T CATE	GORY				
Land	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Torque Waves in Extrusion				\vdash	Einish	\vdash	1	Sequence					

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

100746

Work Order ID 100746

May 1, 2013 7:07:53 AM

Item ID:

D3238-15

Accept

Revision ID:

Item Name: Plate

Start Date: 4/30/13 Start Qty: 5.00

Required Date: 4/30/13

Req'd Qty: 5.00

5

Reference:

Approvals:

Process Plan:

Date:

Tooling:

QC:

Date:

SPC (Y/N):

Sequet. Work Center ...

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ Run Hours

130

130

Handl'inish

Memo

0.00

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

1/10

OC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: \$7 6.3 \(\triangle 0.00 \)

150

Packaging

Memo

0.00

Packaging

N900040100

Setup Start

Stop *NS2*

Cust Item ID:

Customer:

Date: Date: Run

Stop

1001

"col# Plan

Code

Accept - Reject Qty ...

Reject - Insp. Number Stamp

12

12x

es / No				WORK ORDER NON-C	CONFOR	MANCE / UPI		QA Closed:	Date:	
r:				DISPOSITION	_					
o				Rework Scrap	-i I	Machining Small Fat		Prod. Eng. Coor		Engineering Quality Other
NCR No.				Use-as-is Work Order Update	Ineri	Large Fab	Composite	Rec/Stol	Supplier	Other
Date	Step	Qtγ		•	Initial Chief Eng	1		Sign & Date	Verification	QC Inspector
-t-				F.	AULT CATE		B- g .			·\$
Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in Torque W	ot Concer Crimped t n Strip in Bend laves in E	Tube	o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Inspect Instruc Mainte Mislabe Misrea Offset Out of	tion Incomplete tions Incomplete/I enance eled d Calibration	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	tolerance ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Date Date Gear Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W	g Gear Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Waves in E	Date Step Qty g Gear Bending Centre Not Concentric to C Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Oty Description of work order update or Non-conformance Bending General Bend BOM/Route Broken/Damaged Centre Not Concentric to O/S Cracks Crushed/Crimped Burrs Contamination Countersink Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Drawing	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Chief Eng Bending General Bend Grain Hardway Cracks Broken/Damaged Instruction Gracks Broken/Damaged Inspection Strip in Tube Ripples in Bend Cut Too Short Misrea Ripples in Bend Drawing Out of	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update Or Non-conformance FAULT CATEGORY General Bending Centre Not Concentric to O/S Cracks Cracks Broken/Damaged Crushed/Crimped Cuffs Cuffs Cushed/Crimped Cuffs Cushed/Crimped Cuffs Cushed/Crimped Cuffs Cushed/Crimped Cuffs Cushed/Crimped Cushed/Crimped Cuffs Cushed/Crimped Cushe	DISPOSITION Rework Scrap Use-as-is Use-as-is Work Order Update Or Non-conformance Date Step Qty Description of work order update or Non-conformance Chief Eng Description Date Step Qty Order Update Or Non-conformance Chief Eng Description FAULT CATEGORY OR ORDER OR	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Date Step Qty Description of work order update or Non-conformance Bending Bending Centre Not Concentric to O/S BOM/Route Broken/Damaged Instructions Incomplete Date Cracks Broken/Damaged Instructions Incomplete Date Cracks Crack Burrs Instructions Incomplete Unclear Date Instructions Incomplete Date Date Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conforming or Non-conformance Date Step Qty Description of work order update or Non-conforming or Non-conformance Date Step Qty Description or Non-conformance Date Step Qty De	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Chief Eng Description Date Verification Bending Centre Not Concentric to O/S BOM/Route Hardware Crasks Broken/Damaged Inspection Incomplete Burrs Contamination Maintenance Crushed/Crimped Burrs Contamination Maintenance Part Moved Prositioned Wrong Inspection Strip in Tube Ripples in Bend Drawing Original Prover Loss/Surge Content in Drawing Out of Calibration DISPOSITION AGAINST DEPARTMENT/PROCESS Water Jet Water Jet Water Jet Crosstube Machining Small Fab Prod. Eng. Coor. Rec/Store/Packaging Composite Small Fab Prod. Eng. Coor. Rec/Store/Packaging Supplier Composite Crosstube Machining Small Fab Prod. Eng. Coor. Rec/Store/Packaging Composite Sign & Date Verification Sign & Date Verification Sign & Date Verification Grain Date Verification Ovalized Over/Under tolerance Part incorrect Instructions incomplete Inspection Incomplete Part incorrect Part incorrect Part incorrect Part Moved Part Moved Positioned Wrong Power Loss/Surge Offset Out of Softset Out of Softset Out of Calibration

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May 1, 2013 7:07:53 AM

Item ID:

D3238-15

Accept

Revision ID:

Plate Item Name:

Start Date:

4/30/13

Start Qty: 5.00

Required Date: 4/30/13

Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

QC:

Date:

SPC (Y/N):

Sequence Wit Work Center 1D Operation Description

408 Sip/ Run Hours

160

QC21- Final Inspection - Work Order Release

0.00

0.00

160

QC

Memo

Quality Control

Cust Item 1D:

Customer:

Run Start

Setup Start

Stop

rool# Ran خا∍

Date:

Date:

N900040100

Code

Accept Qty

Reject Qty

Stop

Reject Number

lusp. Stamp

D(13.8.15

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			-

TVCTT.		, 110									QA Closed:	Date:	
Work Ord	er:					DISPOSITION		·		AGAINST DE	PARTMENT	/PROCESS	
Part f	Part No.					Rework Scrap	Skid-tube Crosstube Machining Small Fab			Small Fab	Water Jet E Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR 1	No.					Use-as-is Work Order Update] '	nern	noforming Large Fab	Finishing Composite	Rec/stor	Supplier	Other
Root					Descri	ption of work order update	Init	tial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator							İ						
Material	Щ										•		
Setup	Ш				1						,	•	
Other]										
Process											!		
Supplier	<u> </u>												
Training	_										1		
Unapproved	l		l		l				5004		<u> </u>	<u> </u>	
1 . 1							AULT	CATE	GURY		 		
Landi		1			<u></u>	General Bend		rain			Ovalized	<u> </u>	Pressure/Forced
	\vdash	Bending Centre No	st Cancar	ntele to	~/s	BOM/Route	 	rdwa	r0		Over/Under	tolerance	Temperature/Cure
	\vdash	Cracks	or concei	intric to	o', -	Broken/Damaged	—		ion Incomplete		Part Incorre	<u> </u>	Weld
	 	Crushed/	Crimned			Burrs	\vdash	•	ions Incomplete/	Unclear	Part Lost/M	├	Wrong Stock Pulled
	\vdash	Cuffs	cimped		<u> </u>	Contamination	-		enance		Part Moved		7
li .		Heat Trea	ıt			Countersink	h	islabe			Positioned V		
	\vdash	Inspection		Tube		Cut Too Short		isread		 -	Power Loss/		Other
		Ripples in	-			Drill Holes	\vdash	ffset		<u> </u>		- L	
				Extrusio	n 📙	Drawing	-		Calibration				
		Torque Waves in Extrusion Turning Sequence				Finish	\Box	Out of Sequence					

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Picklist Print

May 1, 2013 7:07:52 AM

Work Order ID:

100746

Parent Item:

D3238-15

Parent Item Name:

Plate

Comments:

IPP Rev:A New Issue 06-10-20 EC

IPP Rev:B Now on Waterjet 07-01-26 JLM

Component Item ID/ Item Name

Replacement Item ID

Mfg/ Purch

Bin Primary Item Location

Last

Location

Route Seq ID

100

Unit of Qty on Measure Hand

sf`

0.0000

Qty per Kit Total

Qty

Start Date: 4/30/13

Start Qty: 5.00

Qty Issued

Status Date

Issued

Required Date: 4/30/13

Required Qty: 5.00

-M505211325:020-

Purchased

No

6061T65,020"

m112 442 0.151 A 13.08.12

		DQA:	Date:	
VCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	2;	
Work Orde	or.	•	·			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.						Rework Scrap Use-as-is	Scrap Machining Small Use-as-is Thermoforming Finish			Crosstube Small Fab Finishing	Prod. Eng. Coor. Qualing Rec/Store/Packaging Oth			
NCR N	No					Work Order Update	」		Large Fab C	Composite		Supplier	_	
Root Cause		1 1 1				ption of work order update or Non-conformance	Initi Chief		Action Descripti		Sign & Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						•								
	·	,				<u> </u>	AULT C	ATE	GORY					
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs			General Bend BOM/Route Broken/Damaged Burrs Contamination	Ha Ins	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			Ovalized Pressure/For Over/Under tolerance Temperature Part Incorrect Weld		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled			
	Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion			Extrusion		Countersink Cut Too Short Drill Holes Drawing	Mi Mi Of	Mislabeled Misread Offset Out of Calibration			Positioned V Power Loss/		Other	
	Turning Sequence				-	Finish		Out of Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	9.4F001
Description: Plate	Part Number:	D3238-15
Inspection Dwg: D3238 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

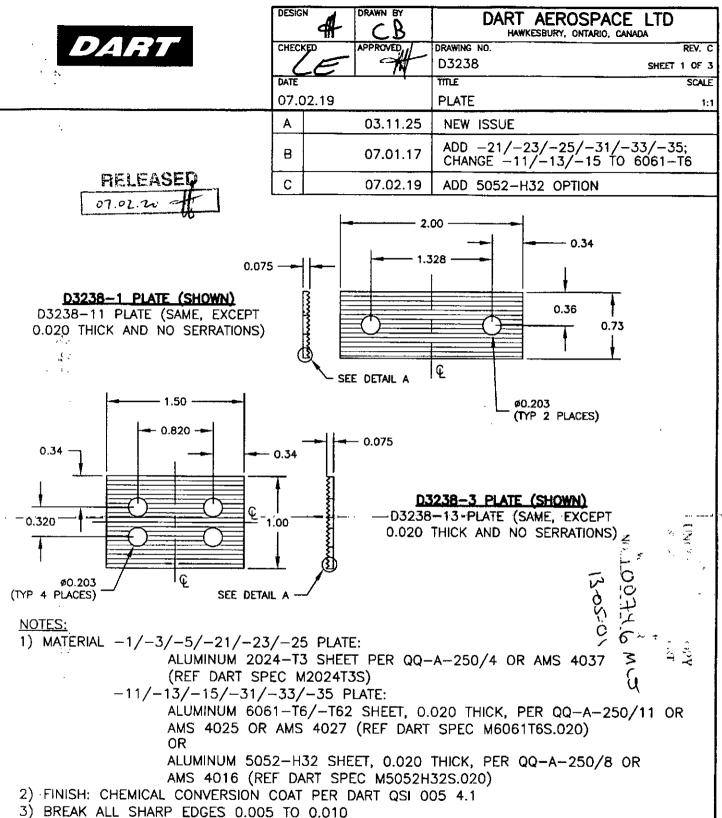
X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	+/-0.030	1.74	-		V	JKM-01
0.70	+/-0.030	-69	-		V	
0.35	+/-0.030	. 35	-		V	
0.36	+/-0.030	, 36	_		N	
1.030	+/-0.010	1.030	-		V	
Ø0.203	+0.005/-0.001	,203	-		V	
				_		
-						
					·	
					u	
				- <u>-</u> -		
			04.			

Measured by:	AL	Audited by:	4.60	Prototype Approval:	N/A
Date:	13.08.12	Date:	13-8-13	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM 1.A	
В	07.02.23	Dwg Rev. updated	KJ/JLM 🚓	B

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•	·			



4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

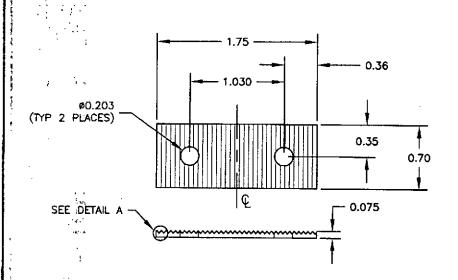
6) SEE SHEET 3 FOR DETAIL A

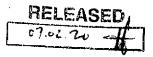
7) PARTS ARE SYMMETRIC ABOUT &

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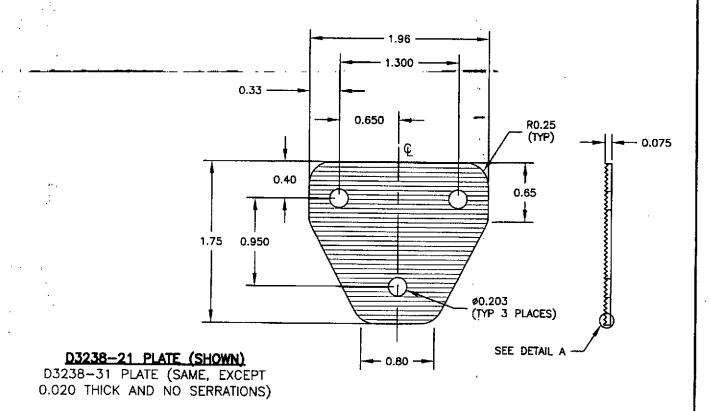
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D3238-5 PLATE (SHOWN) D3238-15 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

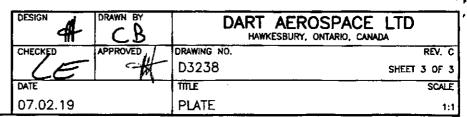


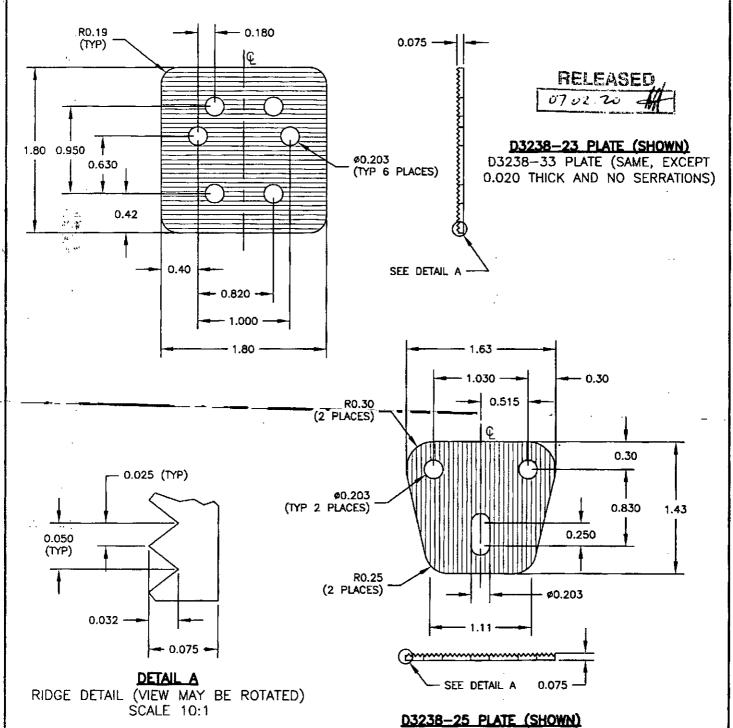
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